

BLUE

Dart Aerospace Ltd.

23

Wednesday 5/16/2007 8:14:43 AM
User: Kim Johnston

Process Sheet

Split-1

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32384
Estimate Number : 10836
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 31252
Written By : 7.05.16
Checked & Approved By : 7.05.16
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
Part Number : D29391
Drawing Number : D2939 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/6/2007 Qty: 4 Um: Each

Additional Product

Job Number



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 13 31386

SA 07.06.26

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly. J-F.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

SA 07.06.26

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 07.06.26

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 07.06.26

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER
REVIEW

Job Number: 32384

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/06/27

(4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L.

07/06/27

(2A)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

2/0: 4005 0267/00105 (4)

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

J.F. 07/07/27

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

L. 7/7/11 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D. 07/07/12 (1)

Job Completion



U 07/07/12

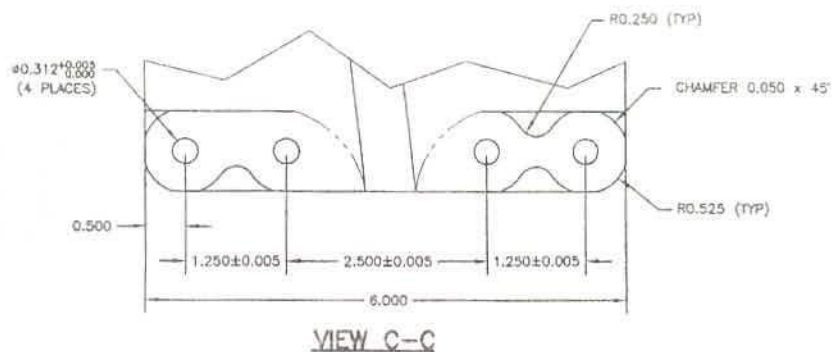
DART AEROSPACE LTD	Work Order: 32384
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.125	.126	.127		
B	0.100	0.140		.125	.127	.127	.126		
C	0.100	0.140		.125	.128	.127	.127		
D	0.210	0.230		.225	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.251	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.501	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.240	.239		
N	0.100	0.140		.120	.119	.119	.119		
O	0.540	0.560		.550	.546	.550	.550		
P	0.490	0.510		.498	.498	.499	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.751	2.751	2.750	2.751		
S	0.240	0.270		.254	.254	.254	.254		
T	0.100	0.180		.137	.137	.137	.137		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.364	1.367	1.363		
W	0.316	0.321		.318	.318	.318	.318		
X	1.250	1.270		1.260	1.259	1.260	1.259		
Y	1.565	1.585	DT8695 A/B	1.575	1.574	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA	Audited by: J.F.
Date: 07.06.25	Date: 07/06/27

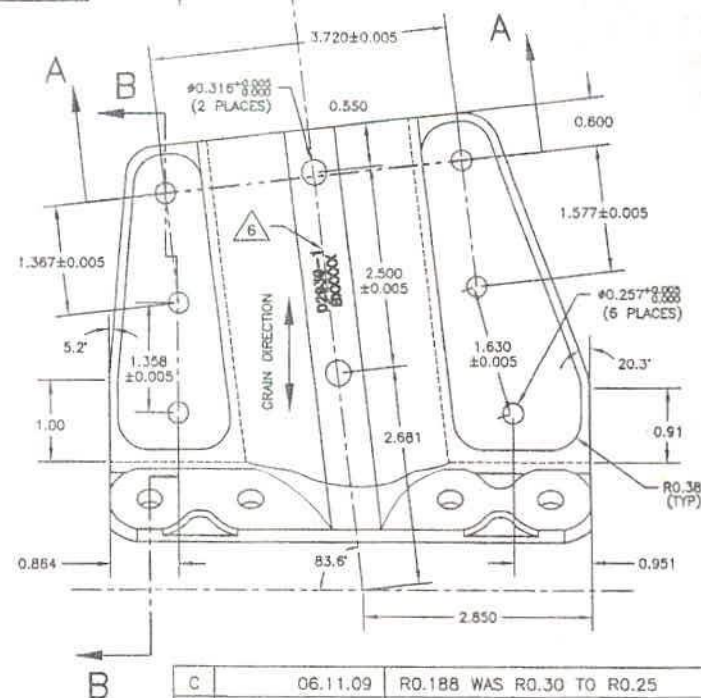
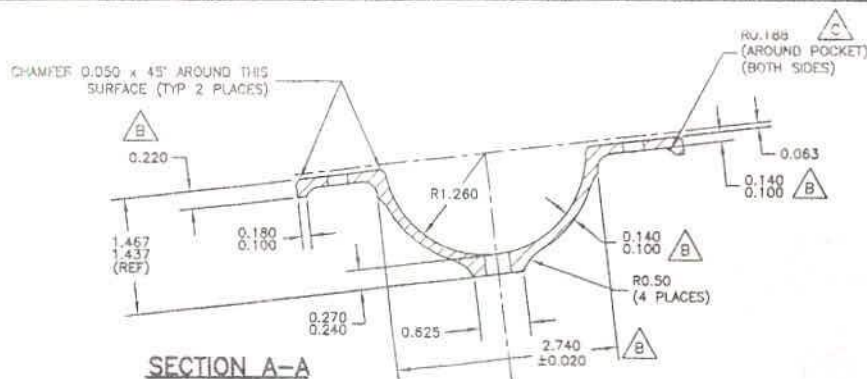
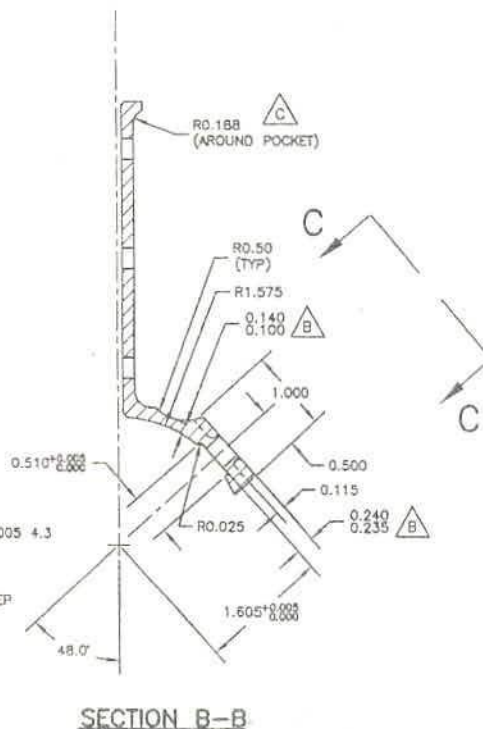
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	<i>PH</i>	DRAWN BY <i>CB</i>
CHECKED	<i>PH</i>	APPROVED <i>PH</i>
DATE	06.11.09	TITLE SADDLE INSIDE
DRAWING NO.	D2939	REV. C
DART	DART AEROSPACE USA, INC.	SHEET 1 OF 1
		SCALE 2:3

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